

# Work Order ID 69692

Monday, May 16, 2011 3:08:01 PM



Page 1

Item ID: D3011-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rappel

Start Date: 5/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*P*

Date: 11-5-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3011	Rev B								

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut Blanks: 26.625"

B.A 11/07/21

4

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

B.A 11/07/25

4

1

Machine as per folio FA129

Folio Rev: AA

Dwg Rev: B

pto →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3011-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: A Date: 11.08.17  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 11.8.19

NCR: <u>69692</u>		WORK ORDER NON-CONFORMANCE (NCR) # <u>245.66</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/07/25	110	→ 1 part scraps <del>document</del> → Part has shifted sideways in the vices because flutes on 3/4 rougher were not the right length → Part have a big dent at right end BC: Operator error LOA	<u>11/07/26</u> <u>Q1012</u>	→ Scrap and destroy → End mill have been changed → replace with B: <u>50630</u>	<u>B.A</u> <u>11/07/25</u>	<u>SL</u> <u>11-07-26</u>	<u>11/07/26</u>	<u>11/06/26</u>

NOTE: Date & initial all entries

# Work Order ID 69692

Monday, May 16, 2011 3:08:01 PM



Page 2

Item ID: D3011-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rappel

Start Date: 5/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				4	0		
Quality Control									
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				4	0		
Quality Control									
131		0.00							
Outsource2	Memo	0.00							
Outsource process - NDT	1- LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG d3011 2- Certificate of conformity is required								

PO 14604

11/08/2 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 69692

Monday, May 16, 2011 3:08:01 PM



Page 4

Item ID: D3011-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rappel

Start Date: 5/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <i>G.A</i>	0.00							
Packaging	Memo <i>w/o</i>	0.00							
Packaging	<i>71346 (4x)</i>								
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*4 0 11/08/10*

*SP11/08/10 (4)*

*CK 11/08/11*

*11-05-10 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 1

Monday, May 16, 2011 3:08:08 PM

Work Order ID: 69692



Parent Item: D3011-1



Parent Item Name: Rappel


Start Date: 5/16/2011

Required Date: 5/18/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C02.05.09 Added D6202 at step 2 NG  
IPP Rev:D Added QC8 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6202 		Manufactured	No			110	f	25.0000	1	4			

I-Beam Extrusion

Location

Loc Qty

Loc Code

MAT028

25

✓50630

25

8.895<sup>44</sup>

J.A 11/07/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

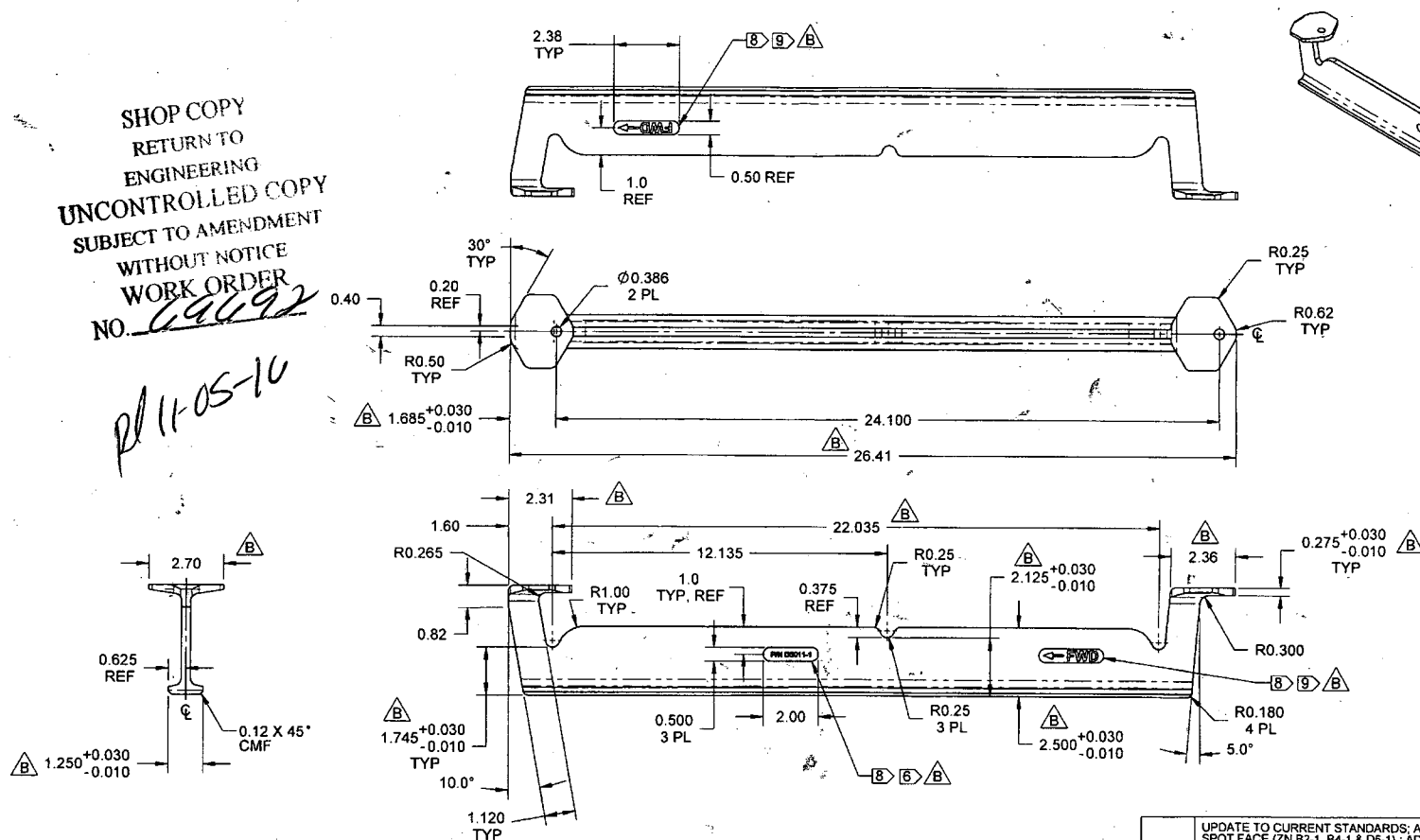
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69692

PL 11-05-10



RELEASED  
09/07/24

# NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6202-027 EXTRUSION
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX DEPTH OF 0.015 IN 0.19 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 3.00 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING
- 9) ENGRAVE "FWD" IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.015 IN 0.38 HIGH LETTERS WITH MIN TOOL RADIUS OF 0.015
- 10) LPI PER ASTM 1417 LEVEL 2

## D3011-1 RAPPEL SLIDE BAR

B	UPDATE TO CURRENT STANDARDS; ADD NOTE 8; ADD SPOT FACE (ZN B2-1, B4-1 & C5-1); ADD DIMENSIONS (ZN B3-1, B4-1 & C5-1); 26.41 WAS 26.32 (ZN C4-1); 2.70 WAS 2.700 (ZN B7-1); ADD (+0.030/-0.010) TOLERANCES; ADD LPI (ZN A8-1)	RF	09.07.24
A	NEW ISSUE	CP	01.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.24		
<p><b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA</p> <p>DRAWING NO. <b>D3011</b></p> <p>TITLE <b>RAPPEL SLIDE BAR</b></p> <p>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</p>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## LIQUID PENETRANT TEST REPORT

P- 05625

CLIENT

ATTENTION

ADDRESS

PROJECT

ITEM(S) EXAMINED

DATE

ACUREN JOB NO.

POWOW NO.

WORK LOCATION

ACCEPTANCE STD.

PAGE

OF

TIME

AM

PM

DAVE AEROSPACE  
LYNDA/CHARLIE/IAN  
1270 ABERDEEN RD  
HALIBURTON ON

July 29/2011  
183-11-02163

PT WET FLUORESCENT ON 9 CROSSBARS & 4 RAPPELS

JOB DESCRIPTION

PROCEDURE NO. LT-003 REV./DATE 2003

TECHNIQUE NO. LT-002

REV./DATE 2003

ART NO.

MATERIAL

ALUMINUM THICKNESS

SCOPE

## TEST DETAILS

METHOD

☒ FLUORESCENT☐ VISIBLE☒ WATER WASH☐ SOLVENT REMOVABLE☐ POST EMULSIFIED

FAMILY BRAND

MACONFLUX

BLACK LIGHT S/N

13798

☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup>☒ AMBIENT < 2 fc

PENETRANT

ZL-67

MINIMUM DWELL TIME

10

Min.

LIGHTING EQUIP.

☐ FLASHLIGHT☐ TROUBLELIGHT☐ OUTPUT > 100 fc @ SURFACE

PENETRANT REMOVER

H<sub>2</sub>O

MINIMUM DRY TIME

&gt;10

Min.

OTHER

DEVELOPER

SKD-52

MINIMUM DWELL TIME

10

Min.

LIGHT METER S/N

CAL DUE DATE

AUG 2011

DEVELOPER TYPE

☒ NON AQUEOUS☐ AQUEOUS☐ DRY

## TEST SURFACE

SURFACE CONDITION

☐ AS GROUND☐ AS WELDED☐ MACHINED☐ SHOT BLASTED☒ CLEAN BARE METAL

SURFACE TEMPERATURE

☐ < -4°C/ 20°F☐ -4°C/ 20°F TO 10°C/ 50°F☒ 10°C/ 50°F TO 52°C/ 125°F☐ > 52°C/ 125°F

## RESULTS-

☐ METRIC☐ IMPERIAL

1	CROSSBAR W.O. ID	69957	ITEM ID	D407-667-205	AFT
2	" W.O. ID	72017	ITEM ID	D012-664-101MB	FWD
3	" W.O. ID	72059	ITEM ID	D012-664-101	FWD
4	" W.O. ID	71825	ITEM ID	D407-667-205	AFT
5	" W.O. ID	71824	ITEM ID	D407-667-205	AFT
6	" W.O. ID	72260	ITEM ID	D012-664-101	FWD
7	" W.O. ID	71437	ITEM ID	D012-664-201	AFT
8	" W.O. ID	72018	ITEM ID	D012-664-201MB	AFT
9	" W.O. ID	71438	ITEM ID	D012-664-201	AFT
10	RAPPEL W.O. ID	69692	ITEM ID	D3011-1	

NO RELEVANT INDICATION WAS DETECTED  
AS PER APPLICABLE STANDARDS

8/11/2012

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the information or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

When performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

REPRESENTATIVE

PRINT

SIGNATURE

DTR # 244712

AN (SIGNATURE):

REPORT

REVIEWED BY:

NAME

INITIALS

CGSB LEVEL

SNT LEVEL

CGSB REG. NO.

CGSB LEVEL

SNT LEVEL

CGSB REG. NO.

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

PT Sept 2005